

ABSTRACT

A control for defining data for setting the times for controlled events in a glass forming machine which is controlled by a programmable sequencer which defines the time of a machine cycle. The control includes a computerized model of a mathematical representation of a network constraint diagram of the unwrapped bottle forming process and a computer for analyzing the computerized model as a constrained optimization problem for determining, with the following data inputs:

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1. the motion durations,
2. the submotion durations,
3. the machine cycle time,
4. the event time in an unwrapped bottle forming process for
- 15 each displacement to begin and for each valve to be turned "on" and "off", and
5. thermal forming process duration "N".

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define the fastest machine cycle time for a feasible schedule and the event time in the unwrapped bottle forming process for each displacement to begin and for each valve to be turned "on" and "off".

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